



Amendments to the Specification:

Please replace the paragraph on page 2, line 28 – page 3, line 7 with the following amended paragraph:




Also, during the roll building phase, the primary arms are ~~programed~~ programmed to move from a roll change position to a roll transfer position, in which the core shaft and the rolls thereon are transferred to a pair of support arms referred to herein as secondary support arms. The secondary support arms are associated with a support drum that is movable on the secondary arms and in relation to the secondary arms so as to come into a supporting engagement with the building rolls while the rolls continue at all times to be engaged with the main winding drum. In addition, the primary nip roll also continues in engagement with the winding rolls, so that the winding of the rolls continues as if on a two drum winder in which both drums are driven, either in a speed or torque mode as desired, and nipped by a driven rider roll. The primary nip roll is released after the winding rolls' weight supplies sufficient nip loading with the support drum.

Please replace the paragraph on page 10, line 30 – page 11, line 2 with the following amended paragraph:



The upper and upstream facing edges of the secondary arms 50 and 51 are provided with rearwardly facing notches 80 that are proportioned to receive an end of the core shaft 20. Cylinders ~~82-81~~ operate notch closing slides 84 mounted on the arms 50 and 51 by which the core shaft may be locked in position in the receiving notches 80 or by which the core shaft may be removed from the notches.

Please replace the paragraphs on page 13, line 12 – page 14, line 5 with the following amended paragraphs:



During the continued winding of the roll set 100A, the primary arms 24, 25 continue to rotate and slowly move the winding set to the +30° from the vertical position as defined. After

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the primary arms are in the 30° position, substantially as shown in Figs. 7 and 8, and the winding roll 100A reaches a specific diameter of say 18", the secondary or support arms are moved slowly back toward the primary drum 22 and are stopped by a proximity switch 120 on the ends of the arms, at the notch 80. During this time the secondary support drum 52 is brought into raised position in a speed mode. The proximity switch 120 indicates that the core shaft 20 is now in the notch, and the position substantially is shown in Fig. 8. At that time, the latch plate 84 is activated by the cylinders ~~80~~ 81 to lock and secure the core shaft in the notch 80 of the secondary arms. The winding now progresses, as shown in Fig. 8, in which the building roll set is wound into the secondary drum while engagement by the nip roll 30 is maintained. The up position of the support drum, at 52, reduces the lift pressure in cylinders 59 to a counter balancing pressure applied by the cylinders 59 to the effect that the loading on the roll 100A is zero or negligible so the primary nip roll 20 loading is dominant.

In a preferred embodiment, in which 60 inch diameter rolls 100 are formed, the initial engagement of the secondary arms as described above and as illustrated in Fig. 8 may take place at about a minimum 18 inch diameter and winding then continues by continuing to drive the secondary drum 52 in the speed mode with the nip roll 30 engaged. This may continue to a predetermined interim position, for example, 24 to 30 inches in diameter. At such a time, the nip roll 30 is retracted, as shown in Fig. 9, while winding continues and the support drum 52 is changed from speed control to the SLAT mode and the support drum changes from balanced to a ~~programed~~ programmed support pressure as applied by the cylinders 58, 59.

Please replace the paragraph on page 18, lines 7-8 with the following amended paragraph:

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The winder is now ready for the next automatic roll change after the programmed footage or diameter on ~~he~~ the winding roll is reached.
